



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-667-101
Job Sheet 188685



08/69

Part No: D206-667-101

Job Qty: 1 pcs

Part Name: Fwd Crosstube - High 206 A/B



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Created By: Jesse White

Due Date: 2/8/19

Description:

Note: DWG D206-667-141 REVD / IIN-D206-667 REV.D IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:ec IPP Rev:H 08-07-28 update as per (par 08-013) DD verified by:EC IPP Rev J 09.01.06 Per ECN 08-562 EC verified by:DD IPP REV:K 11.08.05 PER ECN 11-615 DD VERF:EC IPP REV:L 12.08.20 DSI9628 revA (ECN12-631) DD VERF:JLM IPP REV:M 18.09.13 AS PER DWG D206-667-141 REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Packaging 1 - Pick Kit	1 pcs	2/8/19		0.00	0.00	Packaging 1 - 1	GP 19-01-28
							Packaging 1 - 2	
							Packaging 1 - 3	
							Packaging 1 - 4	
							Packaging 1 - 5	
120	Skidtubes - Bend - 2 - B4B	1 pcs	2/8/19		0.00	3.04	Skidtubes - Bend - B4B	GP 19-01-28
130	QC 15	1 pcs	2/8/19		0.00	0.00	QC 15 - 12	DAS 38 8-89
							QC 15 - 3	
							QC 15 - 38	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	
140	Crosstubes - 2 - B4B	1 pcs	2/8/19		0.00	2.80	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
							Crosstubes - 5 - B4B	
							Crosstubes - 6 - B4B	
150	QC 5	1 pcs	2/8/19		0.00	0.00	QC 5 - 10	DAS 38 8-89
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	

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P.T.O.

FEB 19 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>188688</u> Part No. <u>0700-667-001</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☒ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date : <u>19/1/28</u>	Sequence #:	QTY Affected :	MRB (QSI042) INSP 12 <u>19/1/28</u>					
Description Work Order Deviation <u>Tube is bent center low, -0.23/-0.16 under nominal</u>		Disposition <u>Acceptable. Tube is even and within will not cause fit issue.</u>		Completed By <u>19/1/28</u> Lead hand / Supervisor <u>JTE 19-7-22</u> QC / QA Coordinator <u>68</u> <u>9-89</u> JUL 22 2019				
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:25%; border: none;"> ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled </td> <td style="width:25%; border: none;"> ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function </td> <td style="width:25%; border: none;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up </td> <td style="width:25%; border: none;"> ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread </td> </tr> </table>				☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:								

					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
160	Crosstubes - 3 - B4B	1 pcs	2/8/19	0.00 0.33	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	GA 14-01-30
					Crosstubes - 4 - B4B	
					Crosstubes - 5 - B4B	
					Crosstubes - 6 - B4B	
170	QC 7	1 pcs	2/8/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	DAS
					QC 7 - 38	38
					QC 7 - 41	9-89
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
180	Outsource - 2 - NDT per QSI038	1 pcs	2/8/19	0.00 0.00		CT 19-02-05
190	Packaging 2-1 - Receive - B4B	1 pcs	2/8/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	FEB 06 2019
200	QC 5	1 pcs	2/8/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	FEB 11 2019
						9-89
210	Spray Paint - 2 - B4B	1 pcs	2/8/19	0.00 0.88	Spray Paint - 1 - B4B	19.0.19-2-6

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

230	Spray Paint - 3 - B4B	1 pcs	2/8/19	0.00 0.88	Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
					Spray Paint - 1 - B4B	R.D. 19-2-6
					Spray Paint - 2 - B4B	
240	QC 14	1 pcs	2/8/19	0.00 0.00	Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
					QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 38	
					QC 14 - 41	• AS 19-2-11
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
250	Crosstubes - 4 - B4B	1 pcs	2/8/19	0.00 2.80	QC 14 - 9	
					QC 14 - 68	
					Crosstubes - 1 - B4B	R.D. 19-2-11
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
260	QC 5	1 pcs	2/8/19	0.00 0.00	Crosstubes - 5 - B4B	
					Crosstubes - 6 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS FEB 15 2019 68 9-89
270	Packaging 1-2 - Pick Kit - B4B	1 pcs	2/8/19	0.00 0.00	QC 5 - 9	
					Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	DAS 6 FEB 15 2019 9-89
					Packaging 1 - 4 - B4B	
280	QC 4	1 pcs	2/8/19	0.00 0.00	Packaging 1 - 5 - B4B	
					QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	FEB 19 2019 DAS 69 9-89
290	Packaging 3-1 - Stock - B4B	1 pcs	2/8/19	0.00 0.00	QC 4 - 9	
					Packaging 3 - 1 - B4B	FEB 19 2019 DAS 69 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
295	DC - 1 - B4B	1 pcs	2/8/19	0.00 0.00	Packaging 3 - 5 - B4B	
					DC - 1 - B4B	
					DC - 2 - B4B	DAS 21 FEB 19 2019 9-89

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

300 QC 21 - FG

1 pcs

2/8/19

0.00 0.00

QC 21 - FG - 21

Part Op 120 - (CNC Delta 100 Bender), Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio
 Descriptions: FT

130 - (QC15- Crosstube Dimensional Check)

140 - ***** ENSURE PROPER JIG POSITIONING ***** 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes. 3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. 4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes. 5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes. 6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141. Note: Fwd side has 3x top holes. 7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141. 8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint. 9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141 Inside of Cuff (Do not engrave on outside of tube) 10-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

150 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

160 - (Crosstubes Chemical Conversion) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1- CLEAN CROSSTUBE WITH WASH'N WIPE

170 - (QC7-Inspect Chemical Conversion Coat)

180 - (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Level 2 Attach copy of NDT results to work order P0042487

190 - (Receive & Inspect for Damage & Mat'l Certs) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D206-667-103

210 - (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***MASK AREA UNDER CLAMP PRIOR TO PAINTING AS PER DWG DEO*** 1-Prime inside and outside crosstube as per QSI 005 4.2.1 *****Let tube sit up right for 30mins before hanging***** P4500-P-23 Base Batch: 5143304 P4500-C-23

Catalist Batch: Start time: Finish:

230 - (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Paint outside crosstube with White Imron as per QSI 005 4.2 Imron 55U white paint Batch: 5146086 Imron 125S activator Batch: Start:

240 - (QC14- Inspect Spray Paint)

250 - INSTALL GROUNDING CLAMP AND SEAL WITH SIKAFLEX AS PER DWG A/R SIKAFLEX

BATCH: 138996 Proseal 1-Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports with Proseal 890 per D206-667-141 and QSI 015 A/R Proseal 890 Batch: 5138976 EXP: 6/19 3-Install supports clamps Using Dt9565 as per Dwg D206-667-141 ,Torque to 80-100 IN-LBS. Start: 19-2-11 Finish: 19-2-14 4-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.

260 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** **VERIFY RESISTANCE AS PER NOTE 18 AND DWG ***

280 - (QC4- 100% Inspect kits for completeness)

290 - (Identify as per dwg & Stock Location:), Identify and pack for shipping as per PPP D206-667-101

295 - Photocopy bluefile and create labels as per PPP D206-667-101 CHG005

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-667-101TRN	Crosstube Turning Detail	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	B135096
D2873-043	Nut Plate Assembly	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
D2873-045	Nut Plate Assembly	2 pcs (2 ea)	250-Crosstubes - 4 - B4B	
D2891-1	Support 2.25	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
D3595-063-395	Rubber Cushion 0.63" Wide X 3.95" Long	4 pcs (4 ea)	250-Crosstubes - 4 - B4B	
MS20601-AD4W8	Rivet	14 Ea (14 ea)	250-Crosstubes - 4 - B4B	
MS21920-20	Clamp	4 Ea (4 ea)	250-Crosstubes - 4 - B4B	
AN742D36	Plain Clamp Loop	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
MS21042-3	Nut	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
MS27039-1-08	Screw	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
MS9165-05	Bracket	2 Ea (2 ea)	250-Crosstubes - 4 - B4B	
NAS1149C0332R	Washer	4 Ea (4 ea)	250-Crosstubes - 4 - B4B	
AN5-30A	Bolt	4 Ea (4 ea)	270-Packaging 1-2 - Pick Kit - B4B	5104362
AN5-32A	Bolt	4 Ea (4 ea)	270-Packaging 1-2 - Pick Kit - B4B	5058983-1
AN5-7A	Bolt	10 Ea (10 ea)	270-Packaging 1-2 - Pick Kit - B4B	50123355
MS21042L5	Nut	4 Ea (4 ea)	270-Packaging 1-2 - Pick Kit - B4B	5093592
NAS1149D0563J	Washer	18 Ea (18 ea)	270-Packaging 1-2 - Pick Kit - B4B	5123456

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D206-667-101TRN	1	8	0
250-Crosstubes - 4 - B4B	AN742D36	2	39	0
	D2873-043 S133736	②	35	0
	D2873-045 S125817	②	32	0
	D2891-1	② S140903	12	0
	D3595-063-395	④ S033983	91	0
	MS20601-AD4W8 S066964	④ 14	170	0
	MS21042-3	2	124	0
	MS21920-20	④ S103843	143	0
	MS27039-1-08	2	517	0
	MS9165-05	2	25	0
	NAS1149C0332R	4	3,850	0
270-Packaging 1-2 - Pick Kit - B4B	AN5-30A	4	59	0
	AN5-32A	4	453	0
	AN5-7A	10	3,200	0
	MS21042L5	4	334	0
	NAS1149D0563J	18	1,164	0
Part Specifications				
Specifications could not be found.				



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 1/14/19 1:37 PM dart.white.jesse

Container No: S148566



Part: D206-667-101

Job No: 188685

Serial No/Batch: S148566

Revision: D/D

Inspector:

Exp Date:

Instructions: TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAI

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

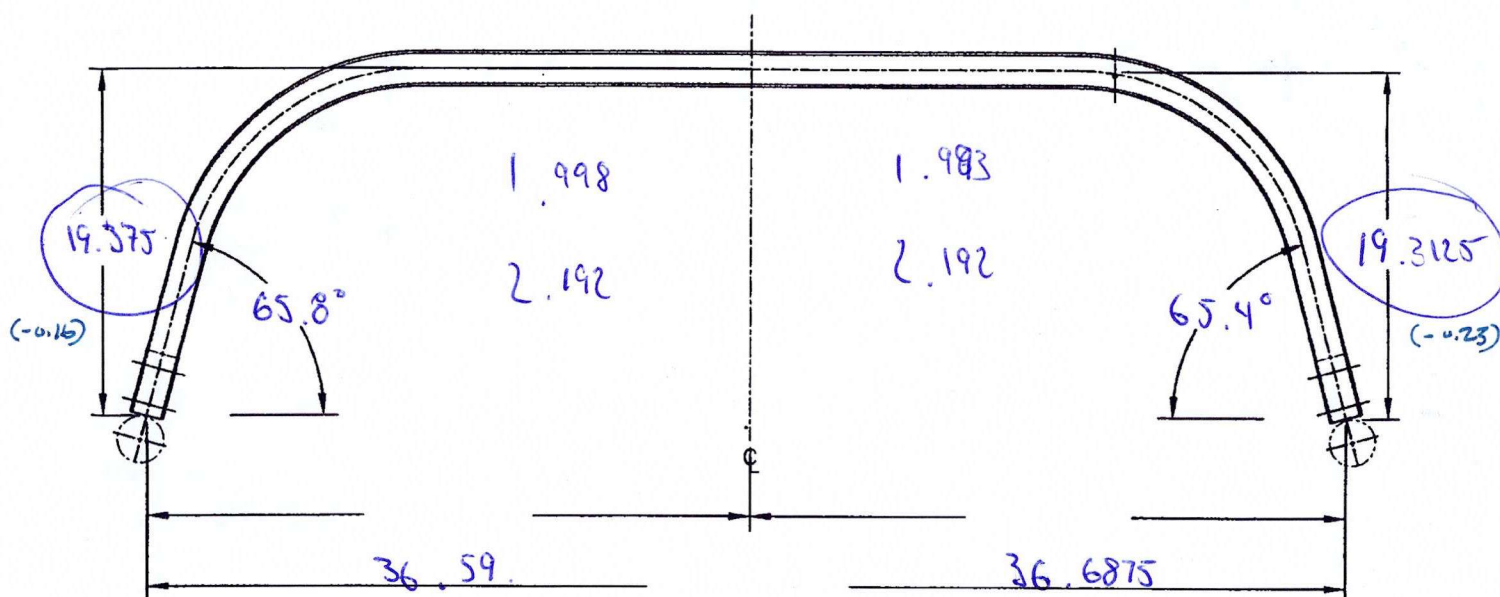
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (206B)		Part Number:	D206-667-101
Inspection Dwg: D206-667-141 Rev: C			Page 1 of 1

Required Dimension	Min	Max
Height	19.41	19.67
1/2 Span	36.47	36.73
Angle	65	67
Total Span	72.94	73.46
Bending Passes	12	--
Crushing	--	6%

19.54



	Side A	Side B
Bending Passes	~30	~30
Crushing	4.6%	4.7%
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.07.30	Dimensions revised per Dwg Rev C	KJ	
C	12.04.16	Added bending, crushing dimensions	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2
10	2	AN742D36	CLAMP
11	2	MS9165-05	ANGLE BRACKET
12	2	MS21042L3	NUT (OR MS21042-3)
13	2	MS27039-1-08	SCREW
14	4	NAS1149C0332R	WASHER (OR AN960C10L)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER 'D206-667-141' AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 11.3 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- TO INSTALL D2891-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, **RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**
- MASK AREA UNDER CLAMP PRIOR TO PAINTING.
- SEAL EDGES WHERE AN742D36 CLAMP MEETS WITH THE CROSSTUBE USING SIKAFLEX-241/-291 OR MIL-S-8802 CLASS B2 OR PROSEAL 890 SEALANT.
- PERFORM RESISTANCE CHECK TO ENSURE MAX RESISTANCE IS 10 MEGOHMS.

RELEASED

2018 SEP 06
B-N 18-797

D	REVISE SHEET 2 ASSEMBLY DETAIL HOLE PATTERN PER CAR18-221. UPDATE PARTS LIST AND GENERAL NOTES 12 & 15 TO INCORPORATE DEO C-1. ADD ITEMS 10-14 TO PARTS LIST AND ADD GENERAL NOTES 16-18 AND ADD SHEET 5 TO INCORPORATE DEO C-2.	JMH	18.05.01
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #8 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	DEF	D206-667-141	SHEET 1 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASSY (206B HIGH FWD)	NTS
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Entered: _____ Date: _____

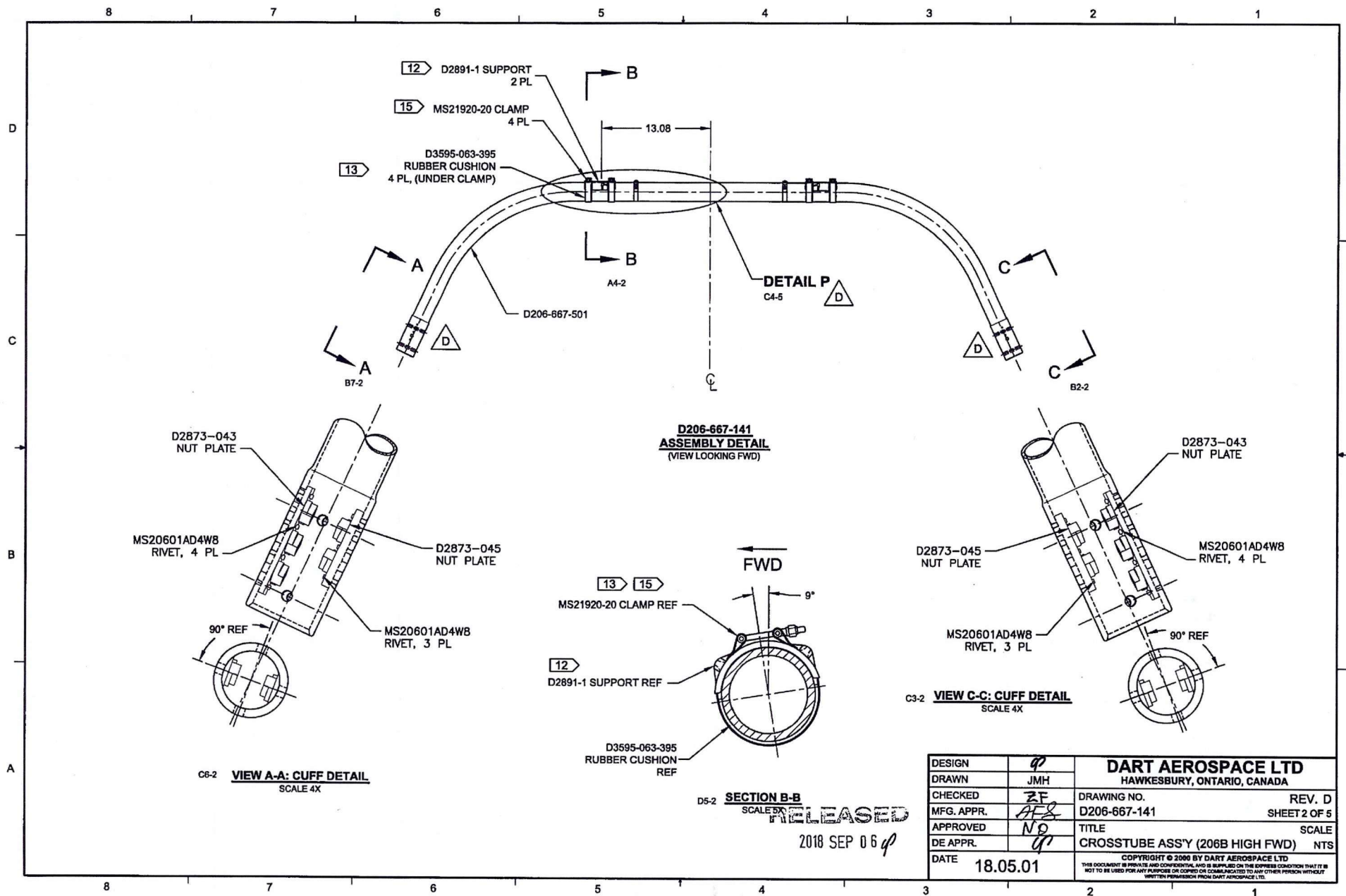


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



DESIGN	Q	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-141	SHEET 2 OF 5
APPROVED	NP	TITLE	SCALE
DE APPR.	Q	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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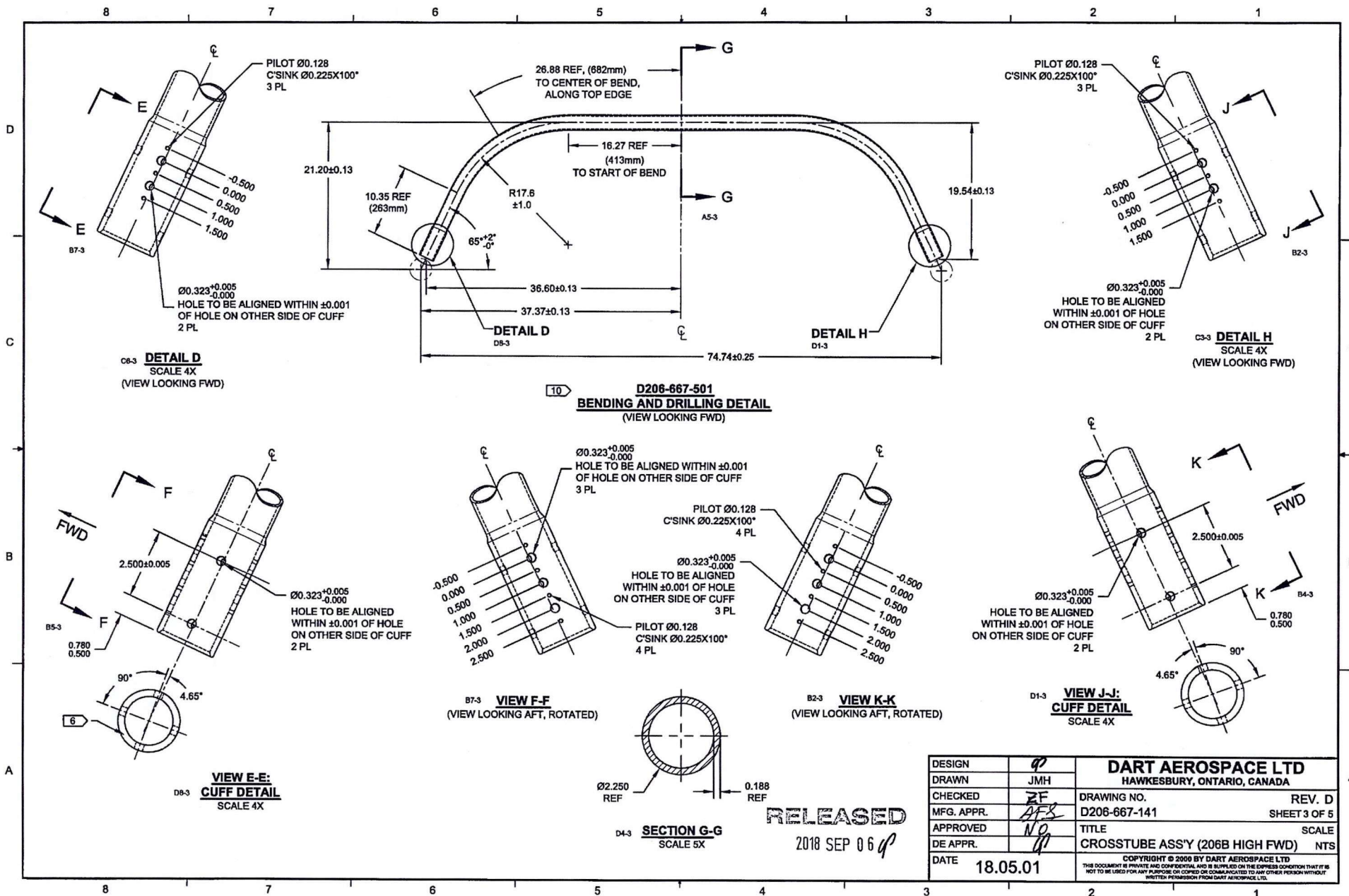


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



DESIGN	9	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFB	D206-667-141	SHEET 3 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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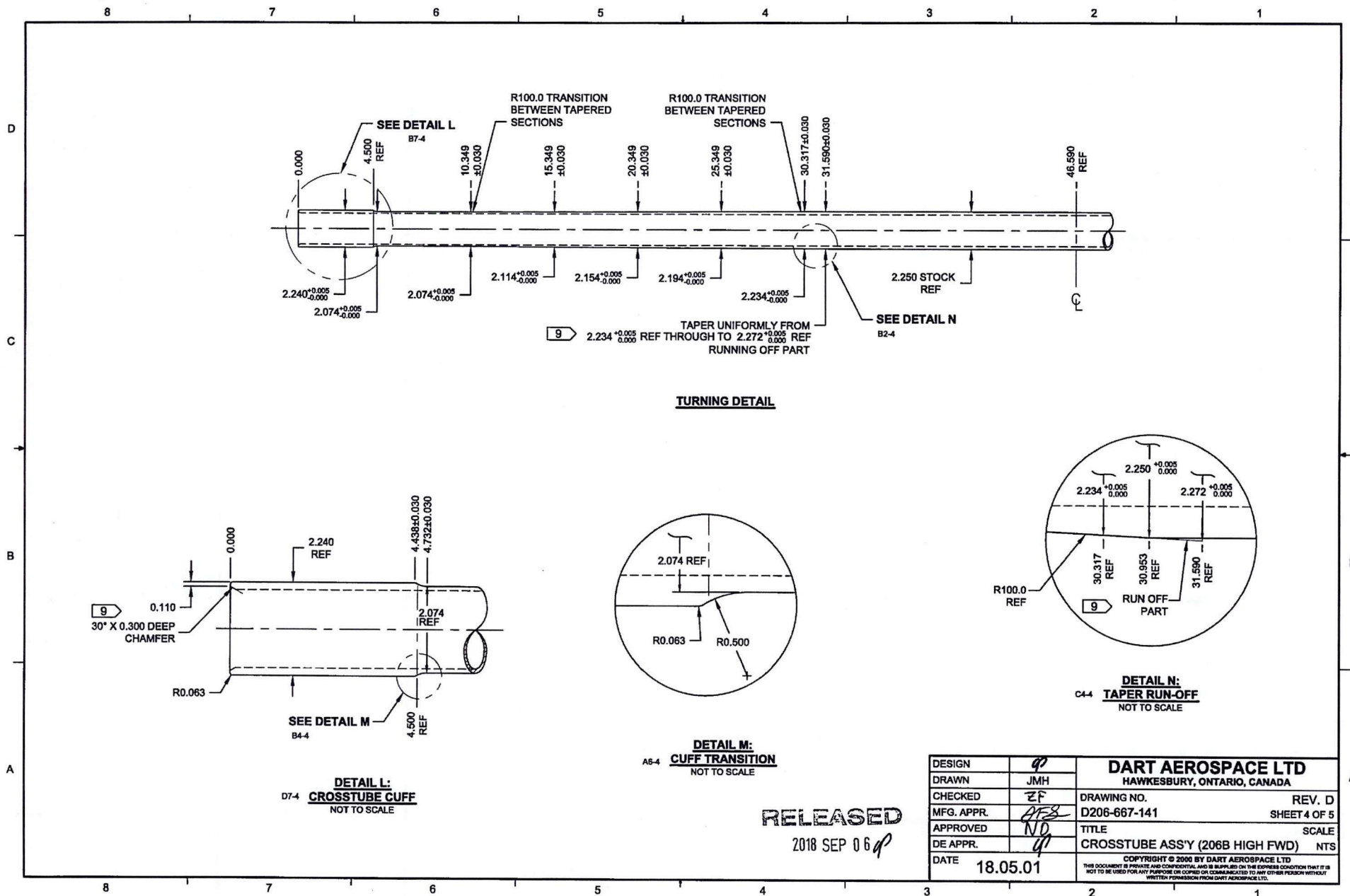


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



DESIGN	q	DART AEROSPACE LTD	
DRAWN	JMH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	RES	D206-667-141	SHEET 4 OF 5
APPROVED	ND	TITLE	SCALE
DE APPR.	q	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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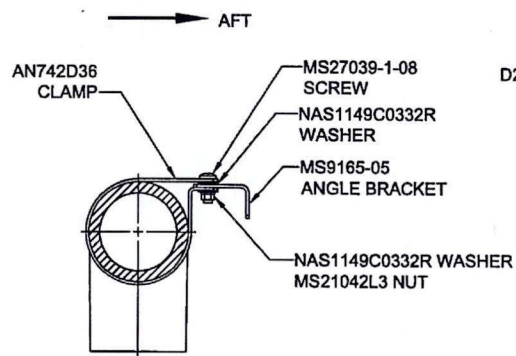


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

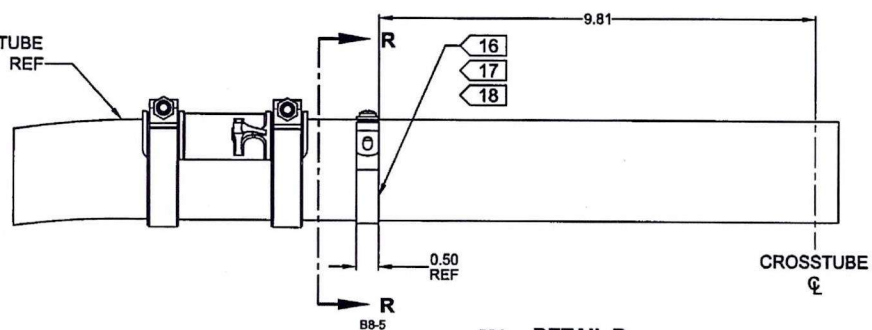
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



C4-5 **SECTION R-R**



D206-667-501 CROSSTUBE
REF



D5-2 **DETAIL P**
BONDING STRAP INSTALLATION 2 PL



RELEASED

2018 SEP 06

DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JMH		
CHECKED	ZF	DRAWING NO.	REV. D
MFG. APPR.	AFS	D206-667-141	SHEET 5 OF 5
APPROVED	NQ	TITLE	SCALE
DE APPR.	qp	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042487

Natasha!

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No:
PO Date
Due Date
Purchas
Revisor
Revisor
Ship-To

You can receive all
the lines except the
last one. I only get pricing
once the part is complete
and it still isn't ready.

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via:
Pymt Te
Freight
Special



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188444	D212-664-107	Fwd Crosstube - Low Standard : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	188445			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
2	189456	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	189457			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042487



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189169	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	183772			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							2	0	2		\$239.00
4	188686	D206-667-101	Fwd Crosstube - High 206 A/B : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Level 2 Attach copy of NDT results to work order (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Level 2 Attach copy of NDT results to work order	Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	188683			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	188684			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
	188685			Firmed	-	2/8/19	1 pcs	0 pcs	1 pcs	\$119.50/pcs	\$119.50
Sub Total:							4	0	4		\$478.00
5	187763	D4880-1	Strut : Various STC's	Firmed	-	2/8/19	8 pcs	0 pcs	8 pcs	\$11.00/pcs	\$88.00
Grand Total:										\$1,283.00	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042487



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/5/19 2:07 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO39182	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: P004 2487
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

2 FWD CROSSTUBES, P/N# D212-664-107, J/S# 188444, 188445

2 FWD CROSSTUBES, P/N D212-664-101, J/S# 189456, 189457

2 AFT CROSSTUBES, P/N# D212-664-201, J/S# 189169, 183772

4 FWD CROSSTUBES, P/N# D206-667-101, J/S# 188686, 188683, 188684, 188685

DAS
9-89

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16							
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715, UV LIGHT M-20142							
<i>Description</i>	<i>Location</i>	<i>P/N</i>	<i>Qty</i>	<i>Batch</i>	<i>S/N Off</i>	<i>S/N On</i>	

FEB 04 2019



I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		FEB 04 2019